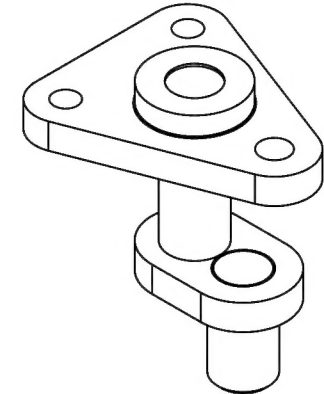
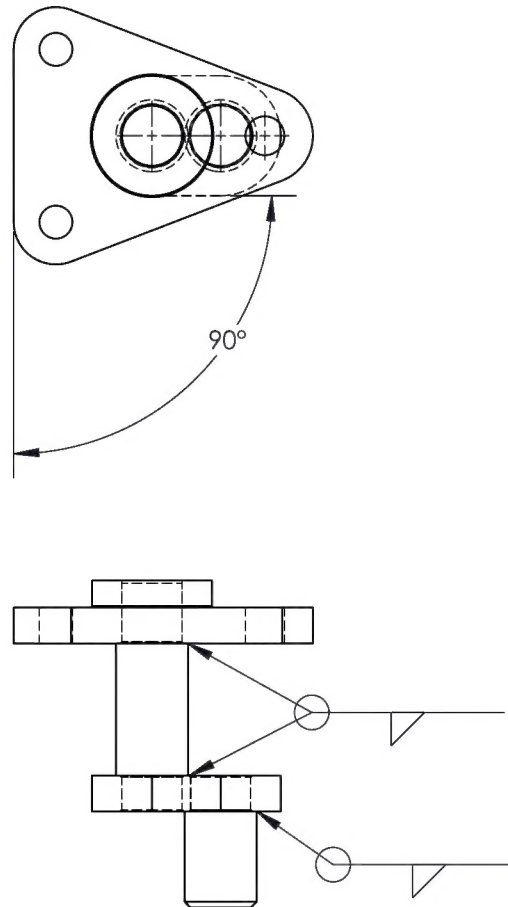
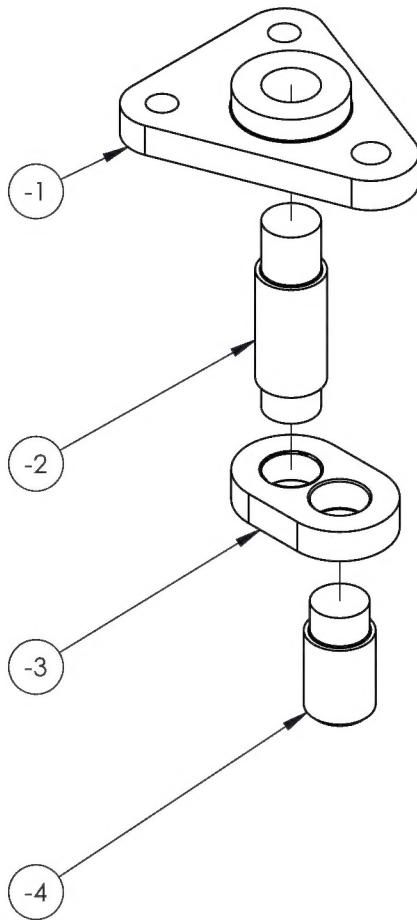


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0186	UPDATED TO NEW DRAFTING STANDARDS. ADDED MATERIAL OPTION 4140 Q&T/4142 Q&T TO -1, -4. ADDED MATERIAL OPTION 1018/1020 TO -3, -4.	7/27/2015	SM	JAG
3	16-0269	UPDATED TO NEW STANDARDS. ADDED DIM 90°. -1 ADDED ENGRAVE NOTE; CH'D DIM WAS Ø.625 IS Ø.626/.625, WAS 1.000 IS 2X 1.000. -2 CH'D DIM WAS Ø.625 SLIP FIT WITH -1 IS Ø.6238/.6231 (S.F. -1), WAS Ø.625 SLIP FIT WITH -3 IS Ø.6238/.6231 (S.F. -3); CH'D MATERIAL WAS 1018/1020 IS 1018/1020 CR. -3 CH'D DIM WAS Ø.625 SLIP FIT WITH -2 IS Ø.626/.625 (S.F. -2), WAS Ø.625 SLIP FIT WITH -4 IS Ø.626/.625 (S.F. -4); CH'D MATERIAL WAS A36 IS A36/1018/1020 HR. -4 CH'D DIM WAS Ø.625 SLIP FIT WITH -3 IS Ø.6238/.6231 (S.F. -3); CH'D MATERIAL WAS 4140 Q&T/4142 Q&T IS 4140/4142; ADDED HEAT TREAT.	12/6/2016	SM	JAG



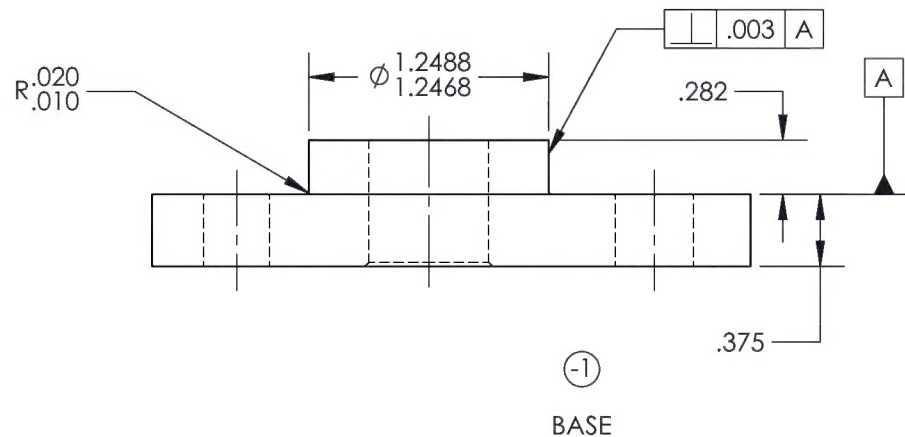
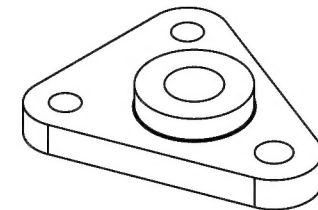
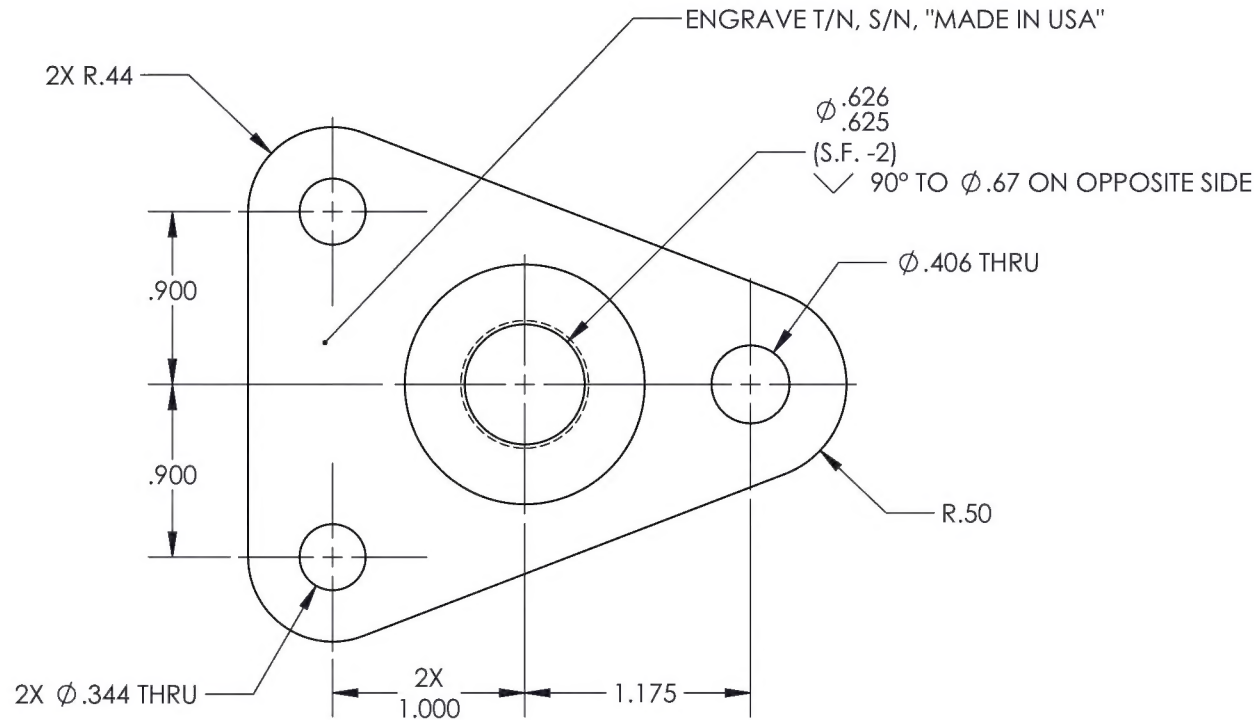
NOTE:
1. ZINC PLATE, ASTM B633 TYPE I SC 2, AFTER WELDING

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BASE	4140/4142		2
			-2	1	MID POST	1018/1020 CR		3
			-3	1	CENTER PLATE	A36/1018/1020 HR		4
			-4	1	END POST	4140/4142		5

DART AEROSPACE	
TITLE ADAPTER-TURNOVER STAND	
DWG NO. RB6798316	REV 3
MAT'L REPT TREAT FINISH SEE NOTE 1	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°
SPEC DRAWN BY: MACKOVJAK CHECKED: CLOUGH OPPS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:2	DATE 7/27/2015
SHEET 1 OF 5	

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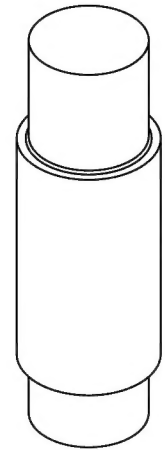
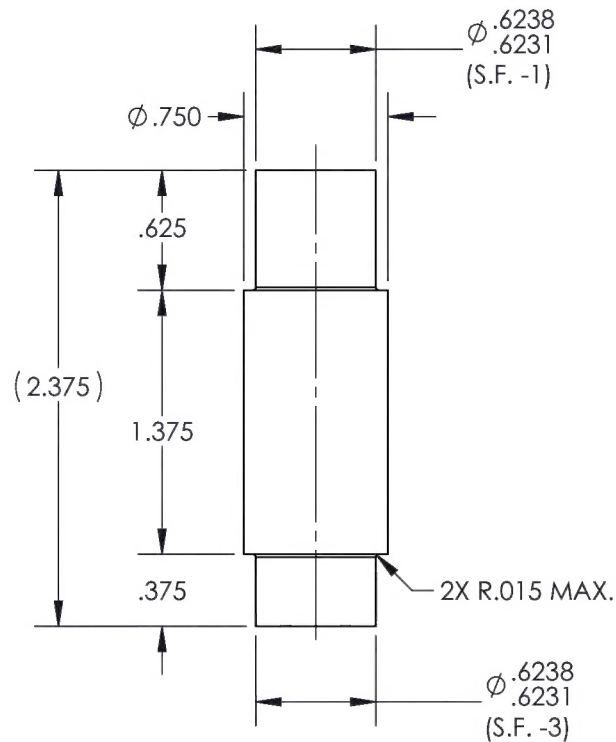
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0186	UPDATE TO NEW DRAFTING STANDARDS. ADD MATERIAL OPTION 4140 Q&T/4142 Q&T TO -1.	7/27/2015	SM	JAG
3	16-0269	-1 ADDED ENGRAVE NOTE: CH'D DIM WAS $\varnothing .625$ IS $\varnothing .626 / .625$, WAS 1.000 IS 2X 1.000.	12/6/2016	SM	JAG



DART AEROSPACE	
TITLE ADAPTER-TURNOVER STAND	
DWG NO. RB6798316-1	REV 3
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 26-32	DIMENSIONS ARE IN INCHES
FINISH SEE SHT. 1 NOTE 1	.XXX \pm .010 FRACTIONS \pm 1/8
SPEC	.XX \pm .03 ANGLES \pm 1°
DRAWN BY: MACKOVJAK	.X \pm .1 SURFACES = 125
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 7/27/2015	USED ON MODEL
SHEET 2 OF 5	250 B15

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0186	UPDATE TO NEW DRAFTING STANDARDS. ADD MATERIAL OPTION 1018/1020 TO -2.	7/27/2015	SM	JAG
3	16-0269	-2 CH'D DIM WAS Ø.625 SLIP FIT WITH -1 IS Ø.6238/.6231 (S.F. -1). WAS Ø.625 SLIP FIT WITH -3 IS Ø.6238/.6231 (S.F. -3); CH'D MATERIAL WAS 1018/1020 IS 1018/1020 CR.	12/6/2016	SM	JAG

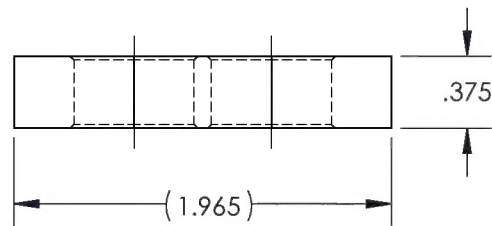
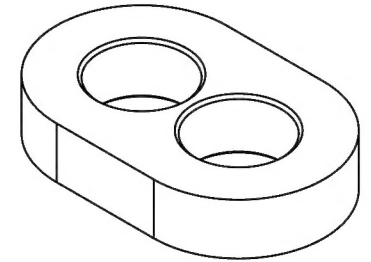
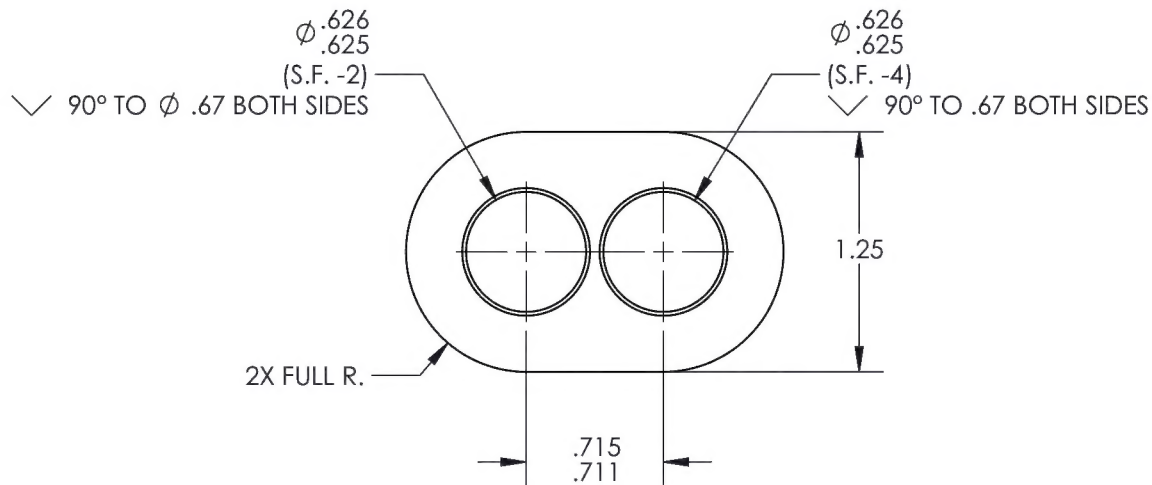


(-2)
MID POST

DART AEROSPACE	
TITLE ADAPTER-TURNOVER STAND	
DWG NO. RB6798316-2	REV 3
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE SHT. 1 NOTE 1	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: MACKOVJAK	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	DATE 7/27/2015
	SHEET 3 OF 5

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0186	UPDATE TO NEW DRAFTING STANDARDS. ADD MATERIAL OPTION 1018/1020 TO -3.	7/27/2015	SM	JAG
3	16-0269	-3 CH'D DIM WAS Ø.625 SLIP FIT WITH -2 IS Ø.626/.625 (S.F. -2). WAS Ø.625 SLIP FIT WITH -4 IS Ø.626/.625 (S.F. -4); CH'D MATERIAL WAS A36 IS A36/1018/1020 HR.	12/6/2016	SM	JAG



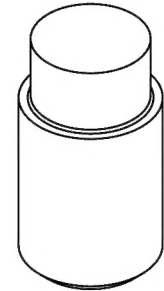
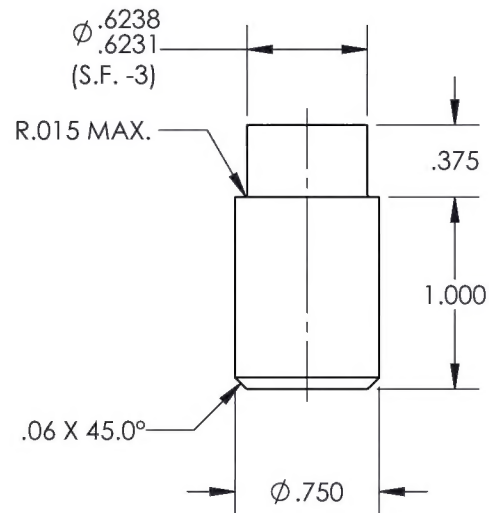
(-3)

CENTER PLATE

DART AEROSPACE	
TITLE ADAPTER-TURNOVER STAND	
DWG NO. RB6798316-3	REV 3
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE SHT. 1 NOTE 1	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125° ✓
DRAWN BY: MACKOVJAK	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	250 B15
SCALE 1:1	DATE 7/27/2015
SHEET 4 OF 5	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0186	UPDATE TO NEW DRAFTING STANDARDS. ADD MATERIAL OPTION 4140 Q&T/4142 Q&T TO -4.	7/27/2015	SM	JAG
3	16-0269	-4 CH'D DIM WAS Ø.625 SLIP FIT WITH -3 IS Ø.6238/.6231 (S.F. -3); CH'D MATERIAL WAS 4140 Q&T/4142 Q&T IS 4140/4142; ADDED HEAT TREAT.	12/6/2016	SM	JAG



-4
END POST

DART AEROSPACE	
TITLE ADAPTER-TURNOVER STAND	
DWG NO. RB6798316-4	REV 3
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 28-34	DIMENSIONS ARE IN INCHES
FINISH SEE SHT. 1 NOTE 1	.XXX \pm .010 FRACTIONS \pm 1/8
SPEC	.XX \pm .03 ANGLES \pm 1°
DRAWN BY: MACKOVJAK	.X \pm .1 SURFACES = 125✓
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 7/27/2015	USED ON MODEL
SHEET 5 OF 5	250 B15